Date:

Friday, 8/8/2008 10:16:54 AM

User:

Chantal Lavoie

Process Sheet

Drawing Name

Part Number

Description:

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 41057

Estimate Number

: 10776

P.O. Number

This Issue : 8/8/2008

Prsht Rev. First Issue **Previous Run** : NC

: // : 41057

S.O. No. :

Type

: PURCHASED PARTS

Written By

Checked & Approved By

Comment

: Est: A 04.09.24

New issue KJ/RF

Material **Due Date**

: 8/15/2008

: N/A

: A

: GASKET

: D33073

- D3307 REV. A

Qty:

8 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Gasket

1.0

D3245



Comment: Qty.:

3560

0.2699 sf(s)/Unit Total:

2.1588 sf(s) 8-8-12

2.0 WATER JET



Gasket

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3307 Dwg Rev:

Prog Rev:_

HB 8-8-12

2-Deburr if necessary

3.0

QC2



HB 8-8-12

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0 PACKAGING ' PACKAGING RESOURCE #1

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:_





Dart Aerospace Ltd

| W/O: | | | WC | ORK ORDER CHANGE | S | | | | | |
|---------|------|-------------------|-------------------------------------|------------------------------|----------------|------------------------|-------|-------------------------------------|--------------------------|--------------|
| DATE | STEP | PROCEDURE CHANGE | | | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| Part No | | PAR #: | Fault Cate | gory: | NCR: Yes | No DQ | 4: | Date: | <u> </u> | |
| | | | | | QA: N | /C Closed | d: | Date: _ | | |
| NCR: | | | WORK ORDI | ER NON-CONFORMAN | ICE (NCR |) | | | | |
| | 0757 | Description of NC | Description of NC Corrective Action | | В | Verific | ation | Approval | Approval | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | | | Chief Eng | QC Inspector |
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Date: User! Friday, 8/8/2008 10:16:54 AM

Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 41057

Part Number: D33073

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08,08,12

| Dart Ae | rospace | e Ltd | | | | | | |
|---|---------|--------------------|---|------------------------------|----------------|-------------------------------------|--------------------------|--------------|
| W/O: | · | | V | ORK ORDER CHANGES | | | | |
| DATE | STEP | P PROCEDURE CHANGE | | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| | | | | | | | | |
| Part No | : | PAR #: | Fault Ca | tegory: NC | R: Yes N | lo DQA: | Date: _ | |
| | | | | | QA: N/ | C Closed: | Date: _ | |
| NCR: | | \ | WORK OR | DER NON-CONFORMANCI | E (NCR) | | | |
| | | Description of NC | Description of NC Corrective Action Sec | | | Verification | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspector |
| | i | | 1 | | 1 | | 1 | 1 |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|------|------|----------------------------------|----------------------|------------------------------|----------------|------------------------|-----------|--------------------------|--|--|
| | | Description of NC | | Corrective Action Section B | | | Approval | Annewal | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Chief Eng | Approval QC Inspector | | |
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Qty:

Each

8 Um:

ate: User:

Thursday, 07/08/2008 4:20:58 PM

Julie Lecoca

Process Sheet

Drawing Name

Part Number

Drawing Number

Project Number

Drawing Revision

: GASKET

: D33073

: N/A

: D3307 REV. A

: 15/08/2008

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 41057 : 10776 **Estimate Number**

P.O. Number

: 07/08/2008 This Issue : NC

Prsht Rev. :11 First Issue

: 22424 **Previous Run**

Written By

Checked & Approved By

Comment

S.O. No. :

Type

: PURCHASED PARTS

Material **Due Date**

New issue KJ/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: PURCHASING

PG 1.0



Comment: PURCHASING

Issue P/O:

Email or Ship DXF file to vendor

water jet Possible Supplier: Specialty Gaskets Inc. or Wawanosh Industrial Services

Laser Cut Flat pattern as per Dwg D3307

Material release note is required

2.0 D33073P Gasket



Comment: Qty.:

1.0000 Each(s)/Unit

Total: 8.0000 Each(s)

GASKET

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieive & Inspect for Transit Damage Ensure Material Release Note is attached

QC6 4.0

DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

PACKAGING 1 5.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:_



| Dart Ae | rospace | Ltd | | | | | | | |
|----------|---------------------------------------|-------------------|----------------------|------------------------------|----------|------------------|-------------------------------------|--------------------------|--------------|
| N/O: | | | W | ORK ORDER CHANG | ES | | | | |
| DATE | STEP | PROCEDURE CHANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| Part No | | PAR #: | Fault Cat | tegon/ | NCP: Ves | No DO | \. | Data | |
| i aitiio | · · · · · · · · · · · · · · · · · · · | ΓΑΙ\ #· | Fault Gat | .egory | | | | _ Date: _ _ Date: _ | |
| NCR: | | | WORK ORI | DER NON-CONFORMA | NCE (NC | R) | | | |
| | | Description of NC | | Corrective Action Section | on B | Verific | ation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Section C | | Approval Chief Eng | QC Inspector |
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Date:

Thursday, 07/08/2008 4:20:58 PM

User:(

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 41057

Part Number: D33073

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

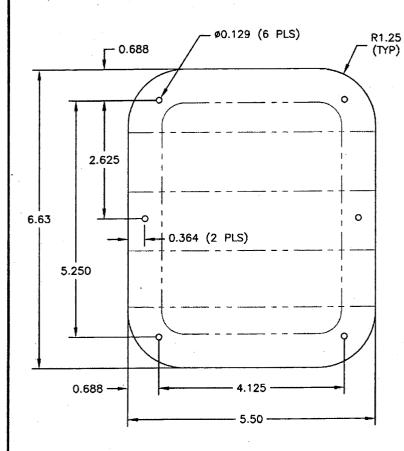


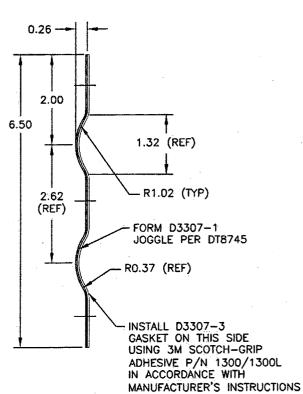
| Dart Ae | rospace | Ltd | | | | | | | |
|---------|---------|-------------------|----------------------|------------------------------|----------------|-----------|--------|-------------------------------------|--------------------------|
| W/O: | | | W | ORK ORDER CHANGES | | | | | |
| DATE | STEP | PR | PROCEDURE CHANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | gory:N | CR: Yes | No DQ | A: | Date: _ | |
| | | | | | QA: N | N/C Close | d: | Date: _ | |
| NCR: | | , | WORK ORD | ER NON-CONFORMANC | E (NCF | ₹) | | | |
| DATE | STEP | Description of NC | ļ | Corrective Action Section B | T 0: | Verific | cation | Approval | Approval |
| DAIL | SILI | Section A | Initial Chief Eng | Action Description Chief Eng | Sign 8 Date | | on C | Chief Eng | QC Inspector |
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| | DESIGN | DRAWN BY | DART AEROSPACE HAWKESBURY, ONTARIO, CAN | |
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| | CHECKED | APPROVED | DRAWING NO. | REV. A SHEET 1 OF 2 |
| ł | DATE | | TITLE | SCALE |
| | 04.09.2 | 3 | ACCESS PANEL ASSEMBLY | 1:2 |
| T | Α | 04.09.23 | NEW ISSUE | |

PELEASED





D3307-1 PANEL FLAT PATTERN

D3307-041 BEND DETAIL
IDENTIFY WITH P/N & B/N
USING FINE POINT
PERMANENT MARKER

D3307-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
REGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

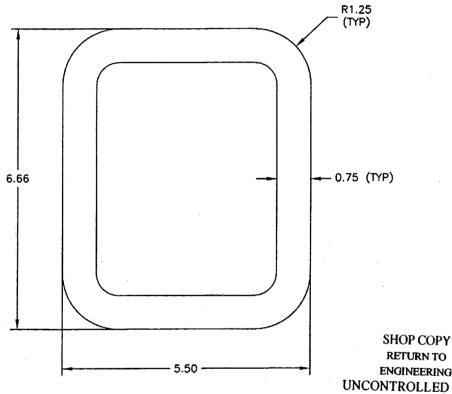
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| DESIGN R | DRAWN BY | DART AEROSPACI HAWKESBURY, ONTARIO, CA | |
|----------|----------|---|------------------------|
| CHECKED | APPROVED | DRAWING NO. D3307 | REV. A SHEET 2 OF 2 |
| DATE | | TITLE | SCALE |
| 04.09.23 | | ACCESS PANEL ASSEMBLY | 1:2 |





D3307-3 GASKET

ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

D3307-3 NOTES:

- 1) MATERIAL: DURABLA BLACK GASKET 0.035 THICK MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3245

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| -DART AEROSPACE LTD | Work Order: 41057 | |
|--------------------------------|----------------------|--|
| Description: CASKET | Part Number: D3307-3 | |
| Inspection Dwg: D3367-3 Rev: A | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------------------------------|-----------|---------------------|--------|--------|-------------------------|----------|
| ، 75 | 4- ,030 | ,749 | × | | | |
| 5.50 | 4/030 | 902,2 | X | | | |
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| Rev | Date | Change | Revised by | Approved |
| | | | KJ/JLM | |
| 1 A | li . | New Issue | I/O/O'LIVI | |